

Date: Thursday, 3/30/2006 10:05:11 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y
Job Number : 26442	
Estimate Number : 10360	
P.O. Number : <i>N/A</i>	Part Number : D2350
This Issue : 3/30/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2350 REV.B
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>SEE ABOVE WORK DATE</i>	Due Date : 4/6/2006 Qty: 5 Um: Each
Checked & Approved By : <i>06.03.30</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6201	T Extrusion 4X4X3/8
-----	-------	---------------------



Comment: Qty.: 1.0631 f(s)/Unit Total : 5.3156 f(s)
Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion
B19492

Batch:

ml 06/04/02

5

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: 12.150" long

ml 06/04/02

5

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio D2363 and Dwg D2363

En 06/04/03

5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE.
-----	-----	---



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/04/03

5

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

31 06-04-03

5

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Tumble & deburr

En 06/04/03

5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2350 PAR #: N/A Fault Category: Red / PAR. ASS ^{med & small} NCR: Yes No DQA: [Signature] Date: 06/04/10
 QA: N/C Closed: [Signature] Date: 06.04.10

NCR: <u>2644 2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/03	3	two holes at the wrong place. was the origins off of two inches.	<u>[Signature]</u>	Scrap & destroy replace.	En 06/04/03	<u>[Signature]</u> 06-04-03	<u>[Signature]</u>	<u>[Signature]</u> 06-04-03
06/04/03	3	1.700 dimension ending is 1.671/1.674/1.671/1.675 (see attached enc.1) * Part 1: 1.671/1.674, Part 2 1.671/1.675	CP 06.04.03	PARTS are OK per DS email	EP 06/04/03	<u>[Signature]</u> 06-04-03	CP 06.03.04 per DS email	<u>[Signature]</u> 06-04-03

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:05:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26442

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.L 06.04.03 5

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M

06-04-04

(5)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M

06-04-04

(5)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

06/04/05

(5)

11.0 D2372 Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372

Fastener

B19507 ✓

12.0 D2444 Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444

Pip Pin

B25811 ✓
B25824 ✓

13.0 AN960JD10L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L

Washer

M18235 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:05:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26442

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) M18917

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw M13719

SB 06/04/06 (S)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/06 (S)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57171

SB 06/04/06 (S)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/04/06 (S)

Job Completion



SB 06/04/07

F15.1

Assemble as per Dwg D2350

SB 06/04/06 (S)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	

RELEASED
960607

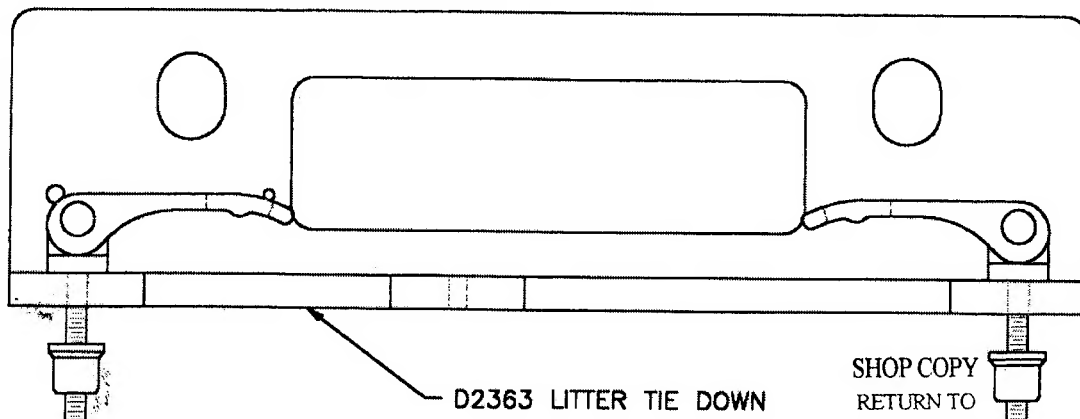
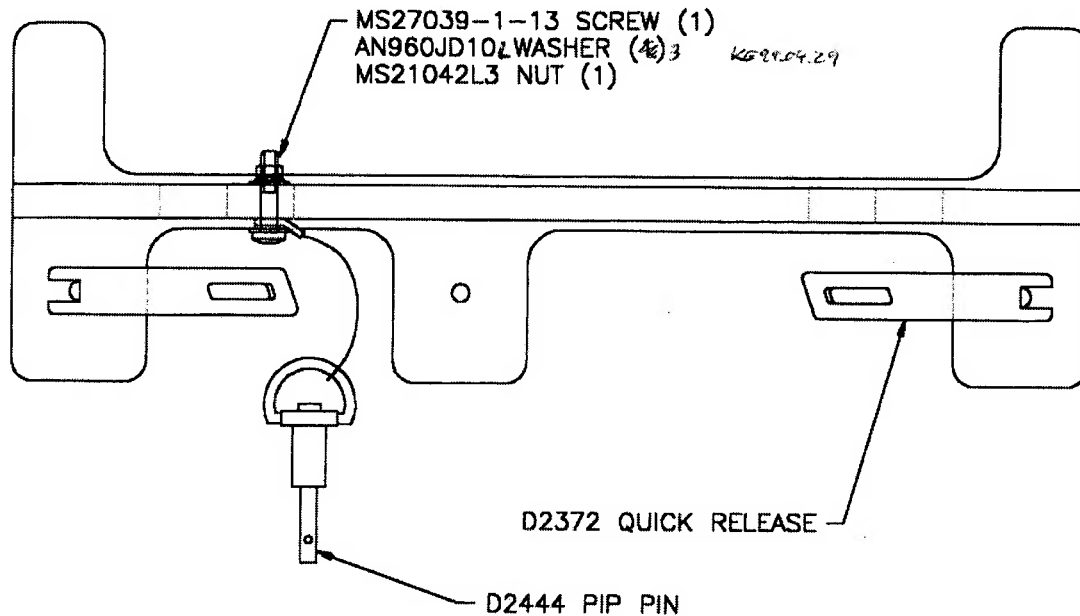
D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>KE 99.04.29</i> 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

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WITHOUT NOTICE
WORK ORDER
NO. 26442



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED	D2350	SHEET 2 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
960607



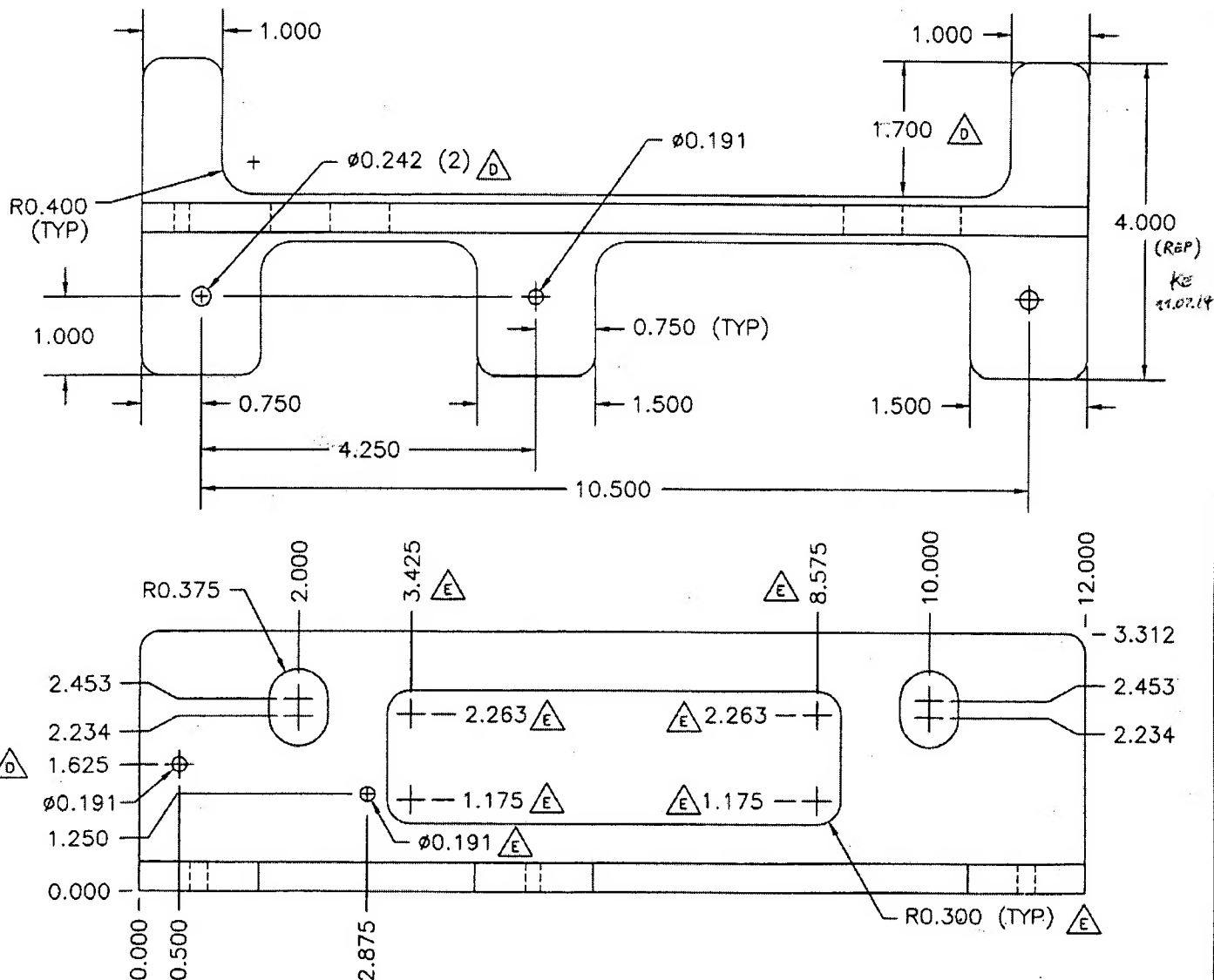
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WORK ORDER

NO. 26442



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIOX	APPROVED BW	DRAWING NO. D2363	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED
971003 KE
TSR 4129



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

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WITHOUT NOTICE
WORK ORDER
NO. 26442

167

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: April 3, 2006 11:39 AM
To: Chris Provencal
Cc: Linda Lacelle
Subject: Fw: NCR D2363 tie down



tie_down.jpg

Chris,

This is an acceptable deviation.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Monday, April 03, 2006 8:39 AM
Subject: NCR D2363 tie down

> Dave,
>
> D2363 tie down. The dimension 1.700 on dwg D2363 Rev.E is 1.671, 1.674,
> 1.671, and 1.675 for each of the four quadrants. The total width is
3.980,
> which on the dwg is listed as 4.000(ref). There is only qty(1) affected
by
> this.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>

* 2 parts affected P 06.04.03

DART AEROSPACE LTD		Work Order: 26442
Description: Litter Tie Down Ass'y		Part Number: D2350
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+ 0.000	0.999	✓			
1.000	+ 0.010	0.999	✓			
1.700	+ 0.010	1.697	✓			
4.000	+ 0.010	3.998	✓			
1.500	+ 0.010	1.501	✓			
10.500	+ 0.010	10.498	✓			
0.750	+ 0.010	0.753	✓			
1.500	+ 0.010	1.501	✓			
4.250	+ 0.010	4.244	✓			
0.750	+ 0.010	0.750	✓			
1.000	+ 0.010	1.001	✓			
Ø 0.242	+ 0.005	0.243	✓			
Ø 0.191	+ 0.005	0.192	✓			
0.500	+ 0.010	0.503	✓			
2.875	+ 0.010	2.877	✓			
Ø 0.191	+ 0.005	0.191	✓			
1.250	+ 0.010	1.245	✓			
Ø 0.191	+ 0.005	0.191	✓			
1.625	+ 0.010	1.620	✓			
2.000	+ 0.010	1.997	✓			
10.000	+ 0.010	9.997	✓			
12.000	+ 0.010	12.002	✓			

Measured by: En	Audited by: J.L	Prototype Approval:
Date: 06/04/03	Date: 06.04.03	Date: /

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

